Date: Tuesday, 4/4/2006 1:32:28 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 26512		
Estimate Number	: 10531		
P.O. Number	: N/A	**Part Number**	: D2572
This Issue	: 4/4/2006 **S.O. No.** : N/A	**Drawing Number**	: D2572 REV E
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : MACHINED PARTS	**Drawing Revision**	: E
Previous Run	: 25997	**Material**	: N/A
Written By	: SEE JA COMMENT BELOW	**Due Date**	: 4/30/2006 **Qty:** 8 **Um:** Each
Checked & Approved By	: KJ 06.04.04		
Comment	: Est: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5

Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2572
Ensure that grain is along 5.00" length
Batch No: B24069 J.G. 06/05/07

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. B26512 Double check by: SA

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove shap edges.

8

SA/J.G 06/05/07

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

SA/J.G 06/05/11

8

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes ~~No~~ **DQA:** _____ **Date:** 06/05/17

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:32:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 26512 **Part Number:** D2572

Job Number:

Seq. #:	Machine Or Operation:	Description :		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		GR/S.G 06/05/12	8
5.0	QC8	SECOND CHECK		
	Comment: SECOND CHECK		MB 06/05/15	8
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		a.m 06/05/16	(8)
7.0	POWDER COATING	POWDER COATING		
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		a.m- 06-05-16	(8)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION		
	Comment: INSPECT POWDER COAT		AR 06/05/16	(8)
9.0	PACKAGING 1	PACKAGING RESOURCE #1		
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST479		AR 06/05/16	(8)
10.0	DC	DOCUMENT CONTROL		
	Comment: DOCUMENT CONTROL Inspection Level 21		D 06/05/17	(8)
Job Completion			M D06.05.17	

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26512
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.746	1.747	1.746	1.746		
C	3.495	3.505		3.498	3.497	3.497	3.498		
D	1.745	1.755		1.746	1.747	1.746	1.747		
E	7.990	8.010		8.004	8.000	8.005	8.001		
F	0.490	0.510		0.497	0.497	0.501	0.501		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.259		
H	0.375	0.380	DT8684	0.377	0.376	0.376	0.376		
I	0.490	0.510		0.493	0.495	0.497	0.498		
J	1.174	1.184		1.178	1.177	1.177	1.176		
K	0.558	0.578		0.566	0.563	0.568	0.567		
L	1.174	1.184		1.178	1.177	1.177	1.176		
M	1.490	1.500		1.493	1.495	1.498	1.499		
N	2.495	2.505		2.497	2.496	2.499	2.497		
O	3.869	3.879		3.872	3.874	3.874	3.873		
P	0.115	0.135		0.124	0.130	0.125	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.260	0.260	0.250	0.249		
S	0.115	0.135		0.125	0.122	0.123	0.124		
T	0.178	0.198		0.188	0.188	0.198	0.188		
U	2.940	2.980		2.960	2.960	2.966	2.960		
V	0.230	0.250		0.240	0.240	0.245	0.246		
W	0.115	0.135		0.126	0.126	0.120	0.121		
X	0.307	0.312		0309	0310	0.308	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.364	0.360	0.359		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.622	0.622	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.253	0.248	0.247	0.248		
AE	1.375	1.395		1.383	1.384	1.381	1.381		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.258	0.256	0.255	0.249		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EO 15.6
Date:	06/05/11

Audited by	MB
Date:	06/05/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	26512
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

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				Recorded Actual Dimensions					
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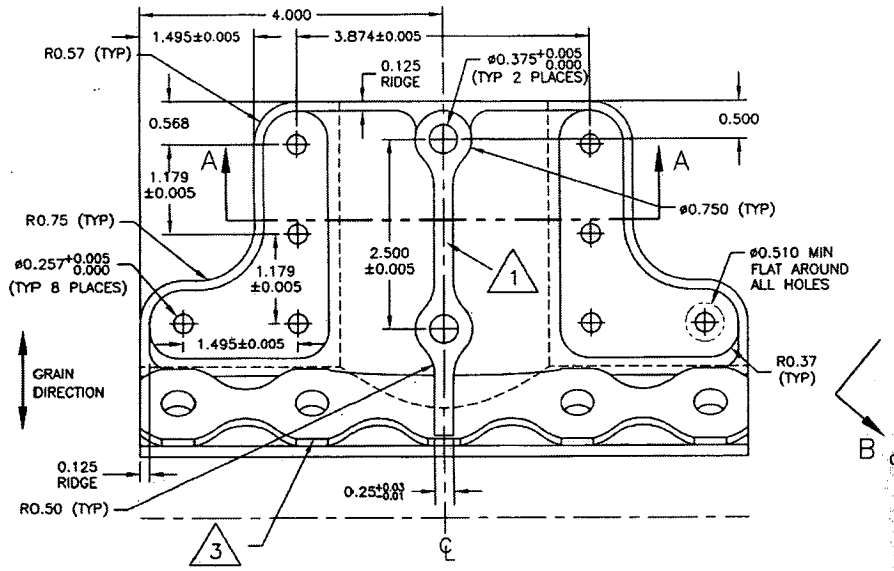
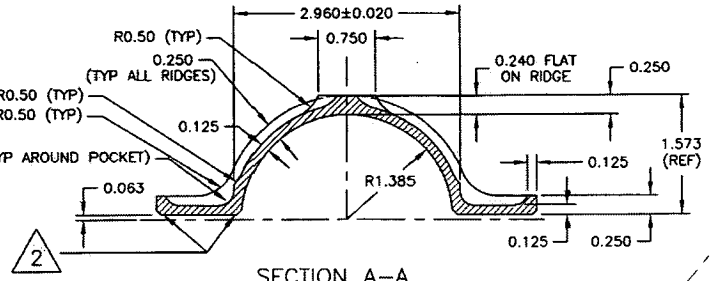
B	1.745	1.755		1.747	1.747	1.749	1.749		
C	3.495	3.505		3.499	3.498	3.498	3.499		
D	1.745	1.755		1.747	1.746	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.000		
F	0.490	0.510		0.501	0.498	0.501	0.502		
G	0.257	0.262	DT8683	0.259	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.501	0.502	0.498	0.500		
J	1.174	1.184		1.179	1.176	1.180	1.179		
K	0.558	0.578		0.560	0.561	0.569	0.568		
L	1.174	1.184		1.179	1.176	1.179	1.179		
M	1.490	1.500		1.497	1.497	1.499	1.499		
N	2.495	2.505		2.499	2.498	2.502	2.501		
O	3.869	3.879		3.872	3.873	3.872	3.871		
P	0.115	0.135		0.125	0.121	0.121	0.120		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.247	0.246	0.246	0.245		
S	0.115	0.135		0.130	0.129	0.129	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.961	2.959	2.959		
V	0.230	0.250		0.249	0.247	0.248	0.247		
W	0.115	0.135		0.119	0.127	0.130	0.130		
X	0.307	0.312		0.311	0.310	0.308	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.369	0.364	0.364	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.631	0.622	0.621	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.248	0.249	0.248		
AE	1.375	1.395		1.382	1.381	1.381	1.381		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.254	0.253	0.252	0.251		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP / J.G
Date:	06/05/11

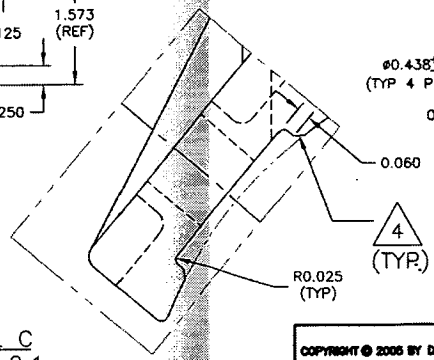
Audited by	MB
Date:	06/05/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



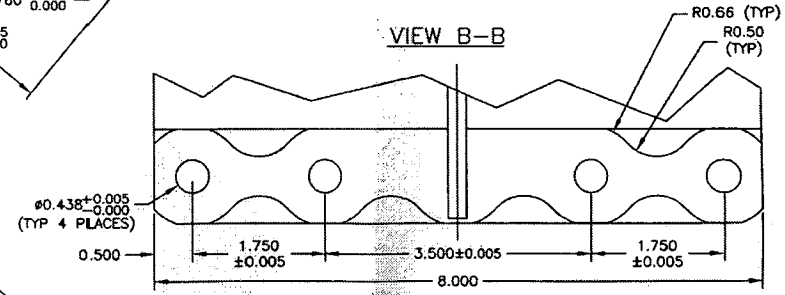


SECTION A–A



DETAIL C
SCALE 2:1

VIEW B–B



RELEASED
05.12.06

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2. CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
3. CHAMFER 0.063 x 45° ALL AROUND
4. CHAMFER 0.033 x 45° (SEE DETAIL C) E

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN: DS	DRAWN BY: PH	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2572	REV. E
DATE: 05.07.13		TITLE: INNER FWD SADDLE	SHEET 1 OF 1 SCALE 2:3

SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 69512